Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-153 **Date Opened:** 09 November 2016 **Title:** Fabrication

Aircraft OEM: Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket Body **Product Model:** Long **Quantity:** 1/1 + LID JC.

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification (Original)	JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
78411	3	Body Assembly	JC
78412	2	Lid Assembly	JC
70405	4	Lid Walkway Mod	JC
84262	2	Basket Handle Prov.	JC
84263	0	Lid Handle Provisions	JC
76421		Hoop	JC

Traveller

Component Completion

	As Instructed
Quantity Complete on This Work Order	1/1
Quantity Incomplete on This Work Order	0
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	JC
Unserviceable (Red) Tag Completed	N/A
Parts Tracking Tags (White) Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Notes:

Stainless steel for prototype development

Work performed by:	Print: J. RECKIE	Sign:	SCA: ADO1	Date: 10 OCT 2018
ICC / Dual Inspection preformed by:	Print: J. CLARKE	Sign:	SCA: ADO2	Date: 10 OCT 2018
Work Order closed by:	Print: J. CLARKE	Sign:	SCA: ADO2	Date: 26 OCT 2018

KADEX Celebrating 20 Years
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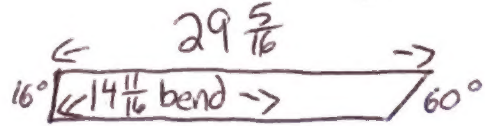
Aircraft Parts
SALES & SERVICE

1" AS350 Med/Long



$\frac{1}{2}$" hoop $\frac{1}{2}$ 22" bend @ $12\frac{5}{8}$

$14\frac{3}{16}$

Aero Design Ltd.
AMF 73-04
9888 A Malaspina Rd.
Powell River, BC
Canada
V8A 0G3

Complete Fabrication Instructions

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.	##########

Nomenclature: AS350 Quick Release Cargo Basket Hoop Work Order #: 2016-153
Number of Units: 4

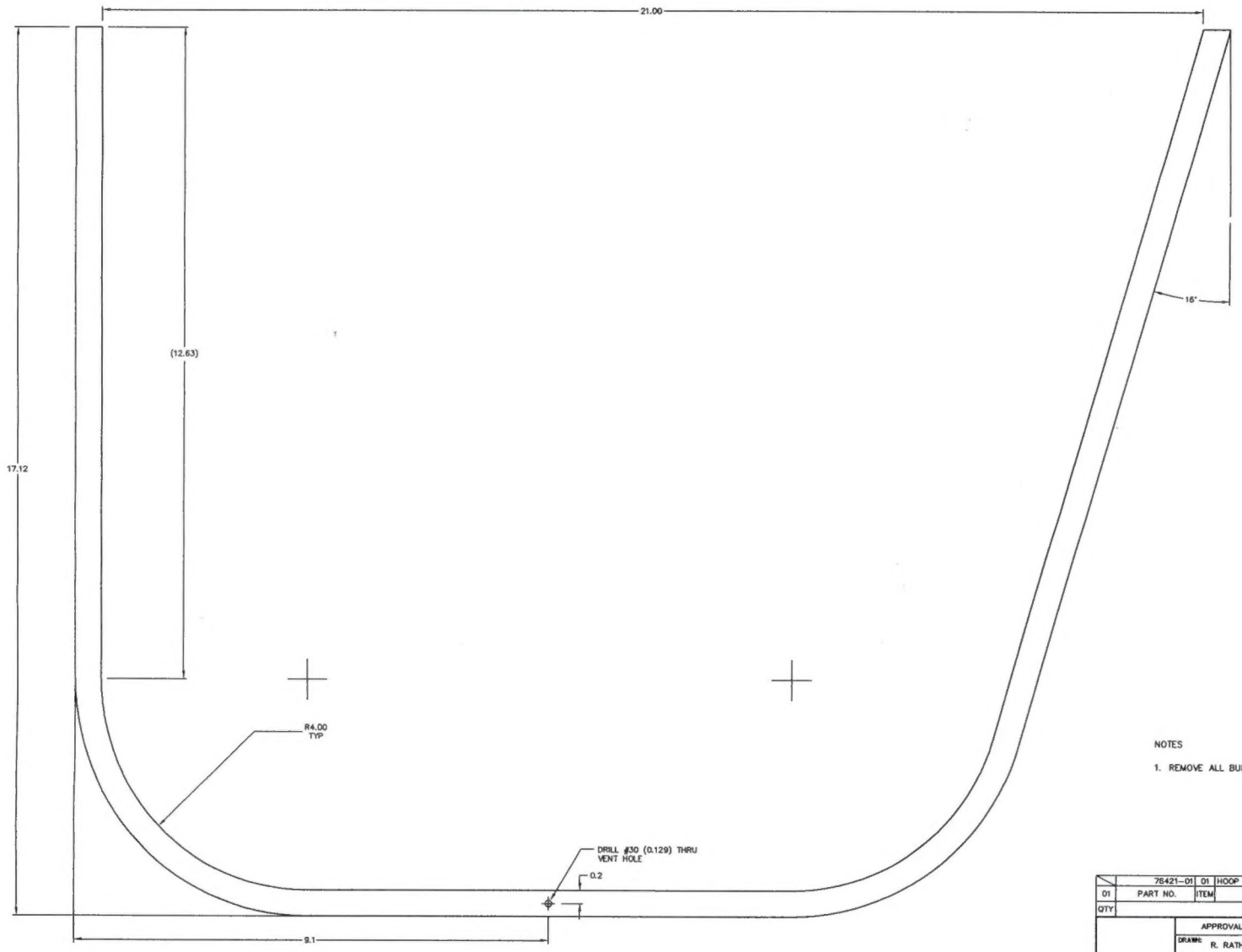
Model	Requirements	Reference	Initial				
AS350	Review LOEP to ensure most current technical specifications	N/A	DB	DB	DB	DB	~~DB~~
AS350	Cut a piece of material to 48 3/16"	N/A	DB	DB	DB	DB	
AS350	Cut one end at 90 degrees and the opposite end at 16 degrees.	N/A	DB	DB	DB	DB	
AS350	At the 90 degree end measure 12 1/2" and mark. Set bend stop at 103 deg. Bend at that mark.	N/A	DB	DB	DB	DB	
AS350	At the longest point of the 16 degree end measure ~~14 1/4"~~ 14 3/16 and mark. Set bend stop at 85 deg. Bend at that mark.	N/A	DB	DB	DB	DB	

Post Fabrication Inspection
Inspect components to ensure conformity to the applicable design data.

Signature: _____
Licence Number or SCA: _____
Date: _____

WO#2016-153 Hoops S.S.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; NOTE 2 REMOVED; ADD VENT HOLE	BJC	11/07/2014



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

01 HOOP
SCALE 1 : 1

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
	76421-01	01	HOOP	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR TUBE

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	R. RATHWELL	24 JAN 08
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2°

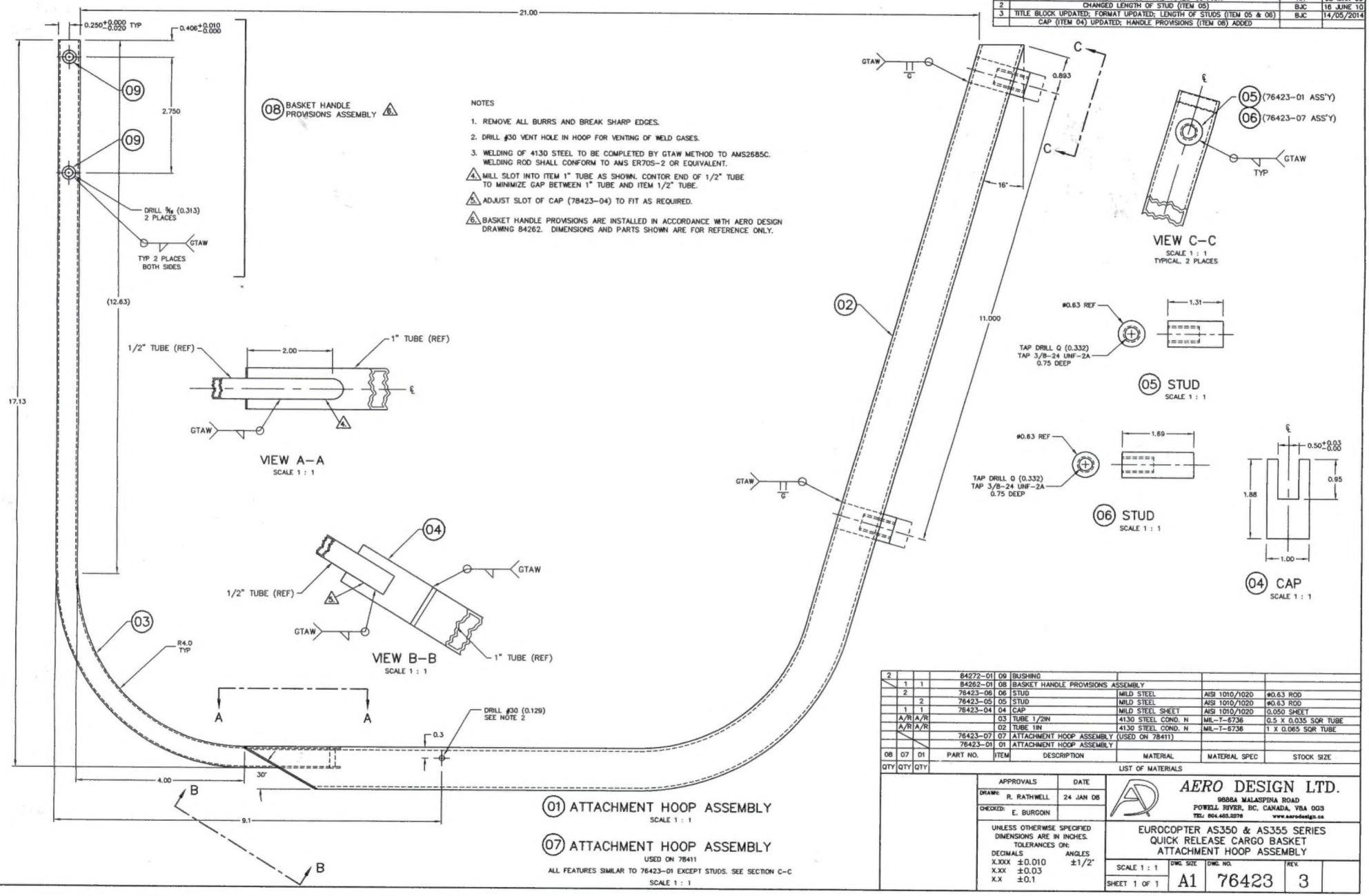
AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0C3
TEL: 604.483.2378 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
HOOP

SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 1	A1	76421	1
SHEET 1 OF 1			

S. S.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08
1	ADDED 76423-07 ASS'Y AND 76423-06 PART	RR	05 MAR 09
2	CHANGED LENGTH OF STUD (ITEM 05)	BJC	16 JUNE 10
3	TITLE BLOCK UPDATED; FORMAT UPDATED; LENGTH OF STUDS (ITEM 05 & 06)	BJC	14/05/2014
	CAP (ITEM 04) UPDATED; HANDLE PROVISIONS (ITEM 08) ADDED		



08	07	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	QTY			LIST OF MATERIALS			
2			84272-01	09	BUSHING			
	1	1	84262-01	08	BASKET HANDLE PROVISIONS ASSEMBLY			
	2		76423-06	06	STUD	MILD STEEL	AISI 1010/1020	#0.63 ROD
		2	76423-05	05	STUD	MILD STEEL	AISI 1010/1020	#0.63 ROD
	1	1	76423-04	04	CAP	MILD STEEL SHEET	AISI 1010/1020	0.050 SHEET
	A/R	A/R		03	TUBE 1/2IN	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR TUBE
	A/R	A/R		02	TUBE 1IN	4130 STEEL COND. N	MIL-T-6736	1 X 0.065 SQR TUBE
			76423-07	07	ATTACHMENT HOOP ASSEMBLY (USED ON 78411)			
			76423-01	01	ATTACHMENT HOOP ASSEMBLY			

APPROVALS		DATE
DRAWN:	R. RATHWELL	24 JAN 08
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2°

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www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
ATTACHMENT HOOP ASSEMBLY

SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 1	A1	76423	3
SHEET 1 OF 1			

CARGO BASKET HOOP FABRICATION - 76423

General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop
84262, Revision 1 – Handle Bracket Assembly

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2016-153 S.S.

Date Open: Nov 2016

Complete (initial or SCA #)

1. ½ Hoop Fabrication – ½" hoop _____
    a. Cut ½" x 0.035 material to 22.0", square ends.
    b. Record material PO on attached material list.
    c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
    d. Remove writing on tubes with acetone and scotch bright.
    e. On the hoop bending fixture, set the following stops:
        i. Upper tube stop: ??"
        ii. Lower bend stop: 12mm
    f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
    g. Slide shim all the way forward on bender to secure tube in die
    h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
    i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
    j. Check for:
        i. hoop height: 17 1/8" (Outside to outside)
        ii. adjust upper stop for height if required

2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01) _____
    a. Start with ½" half hoop from step 1.
    b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
    c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
        i. locate 0.23" from edge (within tolerance specified on drawing).
    d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
    e. Tag in process hoop(s) and place into stock.

CARGO BASKET HOOP FABRICATION - 76423

Complete
(initial or SCA #)

3. ½ Hoop Fabrication – 1" hoop _____
    a. Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
    b. Record material PO on attached material list.
    c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
    d. Remove writing on tubes with acetone and scotch bright.
    e. On the hoop bending fixture, set the following stops:
        i. Upper tube stop: ??"
        ii. Lower bend stop:??
    f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
    g. Slide shim all the way forward on bender to secure tube in die
    h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
    i. Check tube bend for angle using hoop jig. Adjust stops if required.
    j. Check for:
        i. hoop height from jig
        ii. adjust upper stop for height if required
        iii. length to allow 60 degree cut.
    k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
    l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

4. ½ Hoop Machining – 1" hoop _____
    a. Start with 1" ½ hoop as stock.
    b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
    c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
    d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
    e. Set tube in vise with 60 degree end on right.
    f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
    g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
    h. Tag in process hoop(s) and place into stock.

5. Joint Preparation _____
    a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

AO 73-04 05

6. Welding – Lugs _____
    a. Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
    b. TIG weld all around both sides of lugs. 2 places.
    c. Record lug and welding rod PO/WO on attached material list.

CARGO BASKET HOOP FABRICATION - 76423

Complete
(initial or SCA #)

7. Welding – Handle Bushings – 84262-01 AD 73-04 05
    a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
    b. TIG weld bushing both sides, 2 bushings per hoop.
    c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly AD 73-04 05
    a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
    b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
    c. TIG weld around ½" hoop in slot.
    d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
    e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection _____
    a. Run 3/8-24 tap through welded lugs.
    b. Grind inside surfaces flush at lugs and slot in 1" tube.
    c. Inspect hoop for conformity to drawing.
    d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2016-153

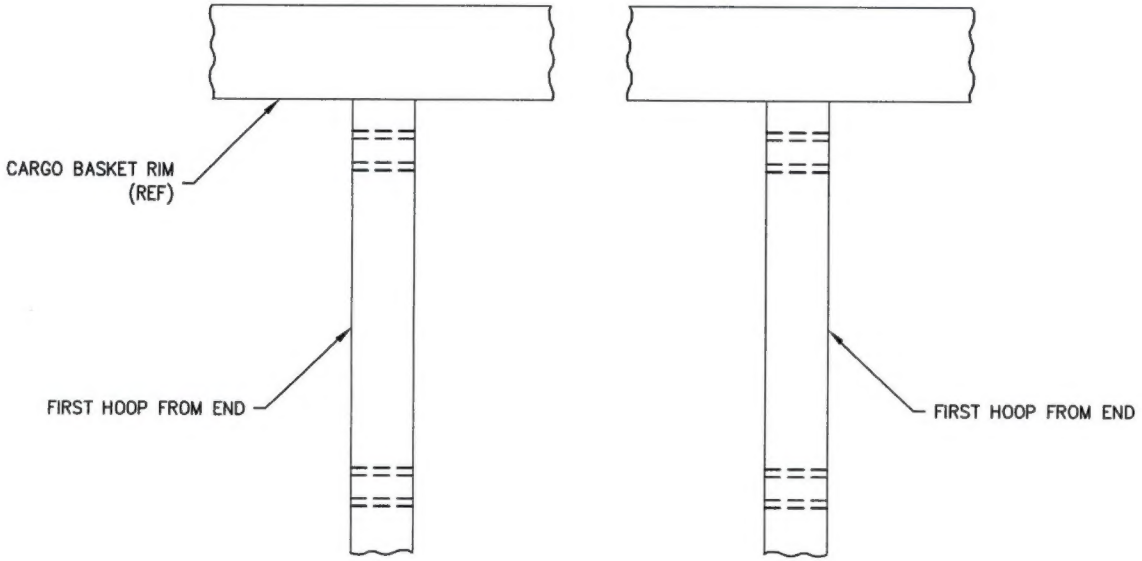
Date Opened: Nov 2016

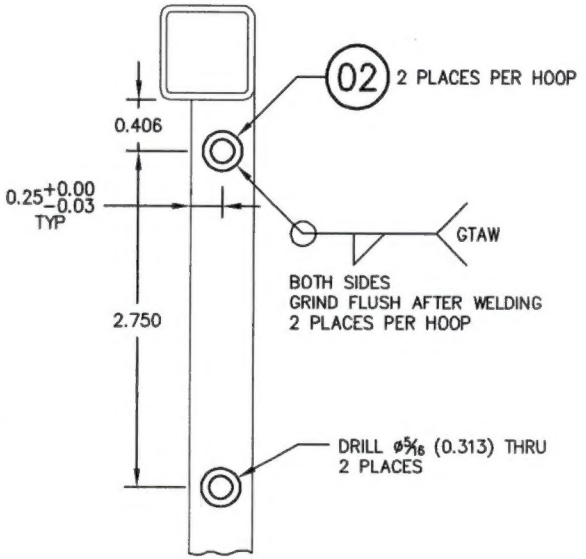
Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Hoops

S.S.

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	4		**76421-01**	**Hoop - standard** S.S.	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	11101
	2		**76423-07**	**Hoop - attachment**		
Step 1				*1/2 Hoop Fabrication - 1/2" hoop*		
	. 1		--	1/2" Tube - hoop S.S.	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	11101
Step 2				*Machining*	*None*	
Step 3				*1/2 Hoop Fabrication - 1" hoop*		
	. 1		--	1" tube - hoop S.S.	~~4130 Steel~~, 1" x 0.065 Sqr. Tube	15073
Step 4				*Machining*	*None*	
Step 5				*Joint Preparation*	*None*	
				Welding		
Step 6	. 2		76423-06	Stud S.S.	~~1018 Mild Steel~~, 5/8" Dia.	16002 S.S.
Step 7	. 2	84262	84272-01	Bushing S.S.	~~4130 Steel~~, 5/16" x 0.058 Rnd. Tube	8065 S.S.
Step 8	. 1		76423-04	Cap S.S.	~~1018 Mild Steel~~, 0.050" Sheet	3021 S.S.
	. A/R		--	Welding Rod S.S.	~~ER70S-2~~	14028 S.S.
Step 9				*Finishing and Inspection*	*None*	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 36262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE LID PROVISIONS TO 84263	BJC	14/02/2014





(01) BASKET HANDLE PROVISIONS ASSEMBLY

PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

QTY	PART NO.	ITEM	DESCRIPTION
4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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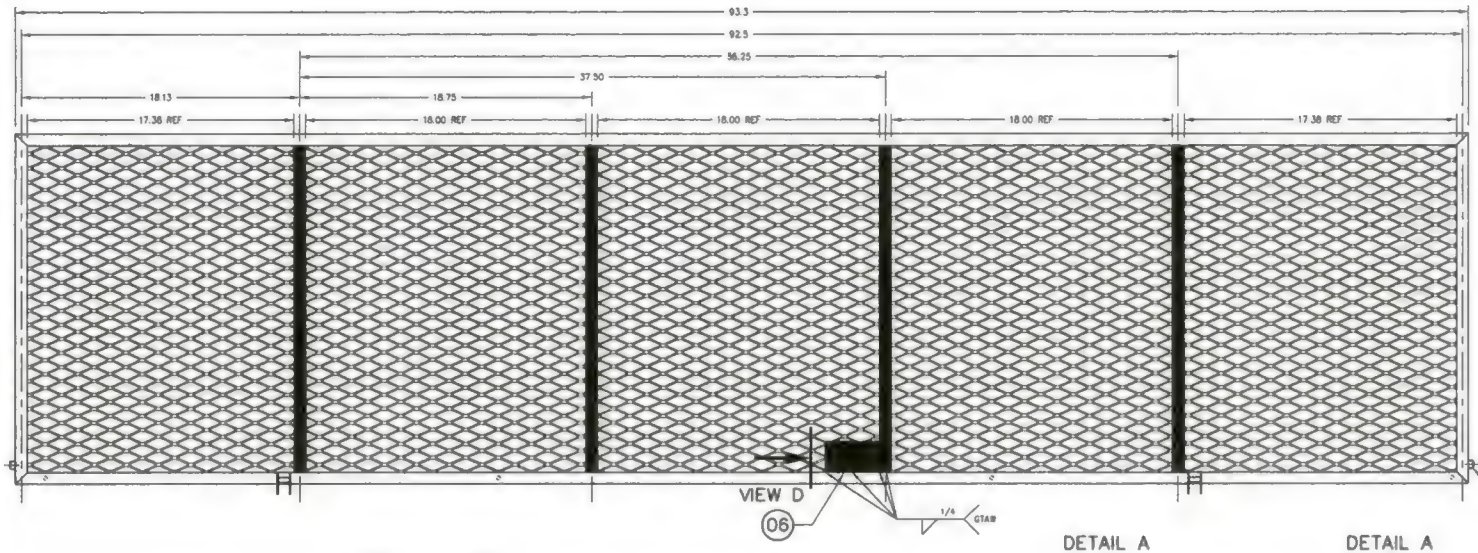
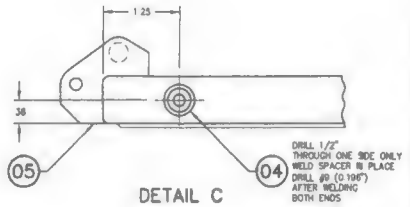
TEL: 604.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
BASKET HANDLE PROVISIONS ASSEMBLY

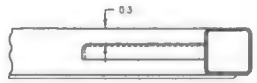
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE BRACKETS, REMOVE ALTERNATE LID	BJC	18 JAN 10
2	TITLE BLOCK UPDATED, 84262 CHANGED TO 84263, WELDING ROD UPDATED.	BJC	10/07/2014
	# OF HOLES CHANGE ON BRACE TO BRACE MEMBERS ADDED REFERENCE DIMENSIONS ADDED		
	1/4" HOLES FOR BUMPERS ADDED, VIEW D ADDED		



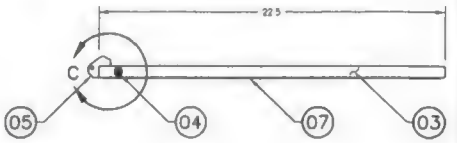


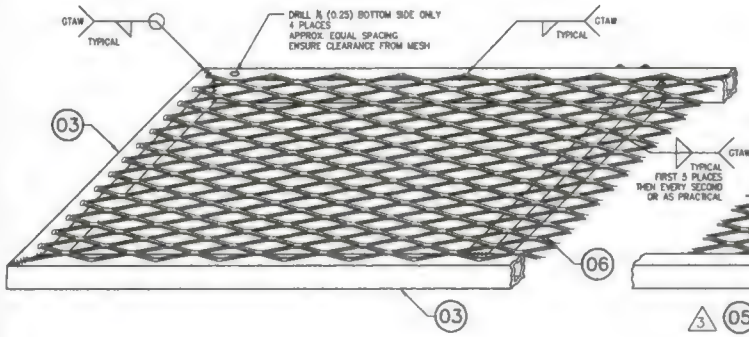
DETAIL C
SCALE 1 : 1



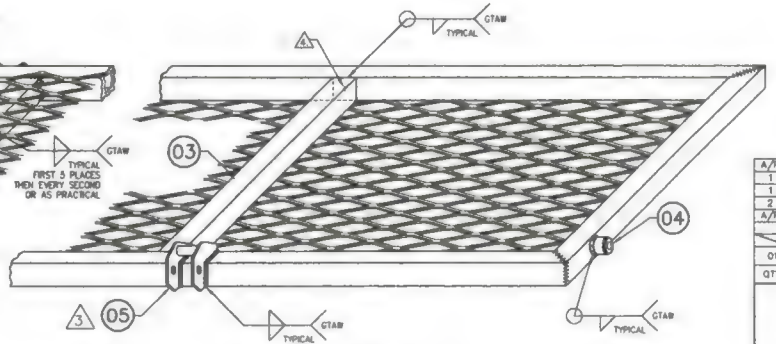
VIEW D
SCALE 1 : 1

01 BASKET LID ASSEMBLY





DETAIL B
LOOKING AT BOTTOM



DETAIL A
LOOKING AT TOP

NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. 4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263
4. DRILL Ø30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
5. FINISH THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY

QTY	ITEM	PART NO.	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
01	01	78412-01	BASKET LID ASSEMBLY			
	02					
A/R	03	--	SQUARE TUBE	4130 STEEL COND. N.	MIL-T-6736	3/4 X 0.035 SQR TUBE
2	04	49216-01	SPACER			
1	05	84263-01	LID HANDLE PROVISIONS ASSEMBLY			
1	06	36204-10	PLACARD BRACKET			
A/R	07	3/4-16F	MESH			

APPROVALS		DATE
DRAWN	R RATHWELL	19 FEB 08
CHECKED	E BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON.
DECIMALS X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES ±1/2°

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EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET LID ASSEMBLY (LONG)

SCALE	DWG SIZE	DWG NO.	REV
1 : 4	A1	78412	2
SHEET 1 OF 1			

Aero Design

Parts Distribution Sheet

AS350 S.S LONG LID

04 Oct. 2018

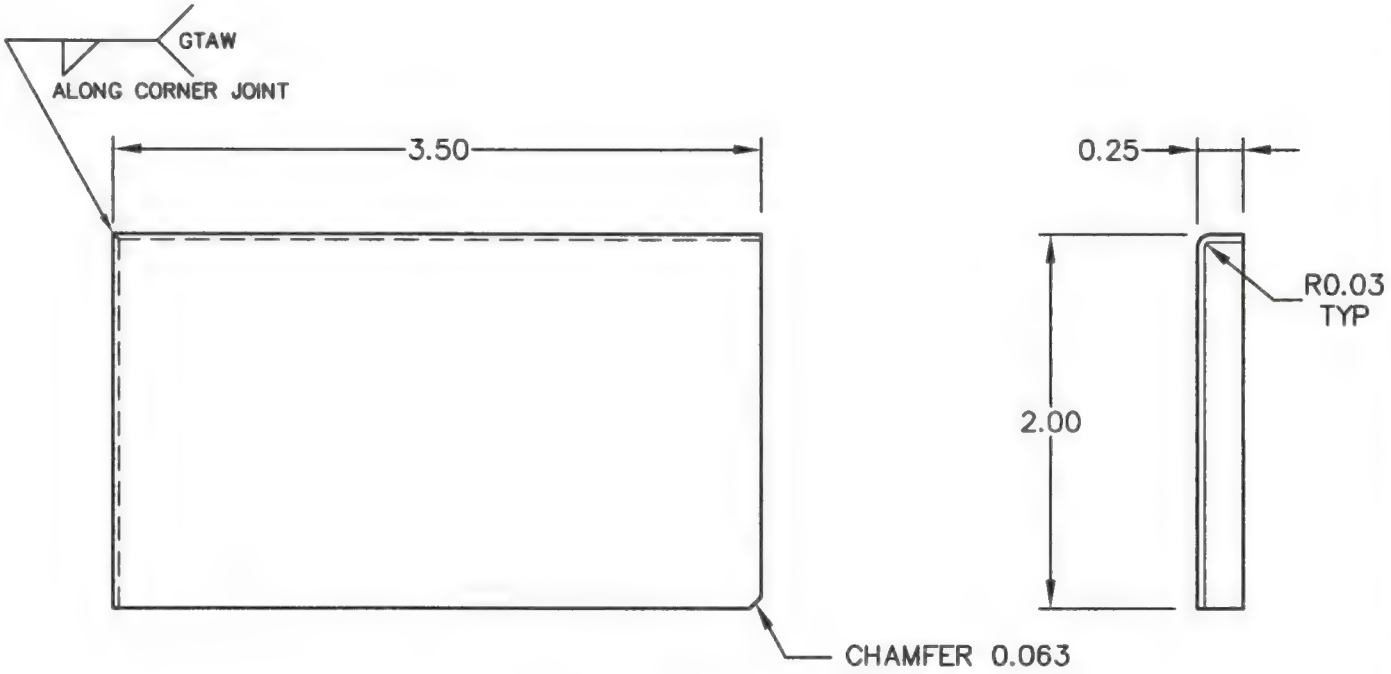
WO# NO W.O

From PO or WO #	Quantity	Description	Part Number	For WO #
18057	8	3/4 x0.035 304 TUBE		
17066		SS. T.I.G. Rod		
16009		S.S. Mesh		
17080		S.S- sheet	Data plate bracket	
2017-201	2	handle bracket assy.	84263-02	
2017-210	2	spacer bushing	49216-01	
18of1		POWDER COATING		
		TRANSCRIBED TO MATERIAL TRACKING SHEET JK		

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
2	SEPARATED THIS PART FROM REMAINDER OF UNUSED DRAWING 36204 REV. 1	BJC	18 FEB 2014
	AND UPDATE TITLE BLOCK		

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 1018 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.



(10) PLACARD BRACKET

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	10	PLACARD BRACKET	1018 MILD STEEL	ASTM A568	0.035 SHEET
01	LIST OF MATERIALS					

APPROVALS	DATE
DRAWN: STEVEN FAHEY	07 OCT 1999
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
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TEL: 604.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET

COMPONENT – PLACARD BRACKET

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	36204-10	2

PLACARD BRACKET – 36204-10

General

These instructions apply to Placard Bracket 36204-10 used for Aero Design cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

36204-10, Revision 2 – Placard Bracket

Work Order: AS350 S.S. Lid (Long) Batch Quantity: 1

Complete (initial or SCA #)

Date Open: 04 October 2018

1. Bracket Fabrication — JF
   a. Part is laser cut from 0.035" mild steel sheet. Enter PO: 17081
   b. On brake, set stop and bend long edge to 0.25" high. Refer to drawing for direction.
   c. On brake, set stop and bend short edge to 0.25" high. Ensure tight fit at corner.
   d. Write WO# on bracket using a permanent marker.
   e. Tag in-progress parts and place on in-progress shelf in welding shop.

2. Welding — AD 73-04 05
   a. TIG weld corner of bracket using ~~ER70S-2~~ ORM 308L rod. Enter PO: 17066
   b. Lightly coat completed parts with WD-40 and store in a zip-top bag.
   c. Tag completed parts and place on in-progress shelf in welding shop for installation.

2016-153

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69812, Revision 4 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket
94612, Revision 1 – Extra-Wide Low Mounted Ski Basket
76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77612, Revision 2 – Short Basket
69812, Revision 4 – Medium Basket (left and right)
78412, Revision 2 – Long Basket
94012, Revision 1 – Extra Large (ski) Basket

Robinson R44 – left or right
90612, Revision 1 – Standard Basket (left or right)

Bell 206B – right side only
80212, Revision 0 – Short Basket
80312, Revision 0 – Medium Basket
81112, Revision 0 – Long Basket

Bell 429 – right or left
95912, Revision 1 – Standard Basket

Bell Medium – left or right
75112, Revision 1 – Standard Basket
95512, Revision 1 – Extra Large (ski) Basket

MD600
82812, Revision 0 – Standard Basket

Options
70405, Revision 4 – Walkway
70402, Revision 2 – Lid Door

CARGO BASKET LID FABRICATION

Complete (initial or SCA #)

	#1	#2	#3	#4	#5
Work Order: 2016-153					
Date Open: 09 Nov 2016					

1. Frame Assembly – Basket Lid — AD 73-04 06 | N/A | N/A | N/A | N/A
   a. Cut and fit ¾" x 0.035 material to fit rim jig, 45 degree ends.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Cut and fit ¾" x 0.035 material, 21" long, for lid cross members.
   c. Walkway modification only: Cut and fit ½" x 0.035 material for walkway stringers to fit between lid cross members.
   d. Drill vent holes into rim to vent cross members. Drill vent holes in cross members to vent walkway stringers.
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
   e. Record material PO on attached material list.
   f. Remove factory writing on tubes with acetone and scotch bright.
   g. Write PO or WO number on tubes with paint pen. Ensure writing is located away from areas to be welded.

2. Weld Frame Assembly — AD 73-04 05 | N/A | N/A | N/A | N/A
   a. Assemble rim jig with jig bars located to position cross members as indicated on drawing.
   b. Clean rim jig to remove any slag that may be present in slots.
   c. Insert outer rim tubes in rim jig. Insert cross member tubes in rim jig.
   d. Walkway modification only: insert walkway stringers in rim jig.
   e. Clamp tube in place to jig.
   f. TIG weld all around all intersections with ER70S-2 welding rod.
   g. Record welding rod and material PO numbers on attached material list.
   h. Write WO number on frame using paint pen.

3. Inspection and clean up — AD 73-04 06 | N/A | N/A | N/A | N/A
   a. Frame assembly for complete welds.
   b. Remove all PO numbers and other markings from tubes. Ensure WO number remains.

4. Mesh assembly — AD 73-04 06 | N/A | N/A | N/A | N/A
   Note: 95912 (Bell 429) does not have mesh. Skip to step 7.
   a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
   b. Cut mesh to size for lid.
   c. Remove surface rust with scotch-brite.
   d. Ensure lid is prepared for mesh on the correct side.

5. Weld mesh to frame assembly per drawing — AD 73-04 05 | N/A | N/A | N/A | N/A
   a. General welding requirements for all lids:
      i. Every intersection on all edges.
      ii. First 5 intersections along cross members, then every second intersection.

	#1	#2	#3	#4	#5

b. Install lid frame in jig, upside down (side to be meshed up), using ¼" spacers to allow all tubes to engage in jig.
c. MIG weld both short sides and tack long sides approximately every 9".
d. Remove lid from jig. Re-install with spacer(s) at centre of lid to pre-tension mesh.
   i. ¾" for lids under 76" at center (check).
   ii. 1" for lids over 76" at ¼ way from each end (check).
e. Weld remainder of mesh as indicated in a.
f. Record welding rod PO on attached material list.

6. Weld lid components — AD 73-04 05 | N/A | N/A | N/A | N/A

a. Handle brackets, locate in accordance with drawing.
   i. Standard location: ¼" outside of last cross member on both ends.
   ii. Record handle bracket WO and welding rod PO on attached material list.
b. Lid prop bushing(s).
   i. one or two in accordance with drawing.
   ii. Record lip prop bushing WO and welding rod PO on attached material list.
c. Placard bracket. – not installed on 95912 (Bell 429)
   i. Locate on cross member to set bracket in centre bay of lid.
   ii. Record placard bracket WO and welding rod PO on attached material list.
d. Complete in-process tag, noting remaining steps. Ensure paperwork is complete to this point.

7. Clean up — AD 73-04 06 | N/A | N/A | N/A | N/A

a. Grind high spots off mesh welds.
b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
c. Straighten lid using frame attached to shear. Work carefully, avoid excessive force to prevent kinking rim tubes.
d. Remove surface rust with scotch-brite pad.
e. Remove all writing/paint pen marks using acetone.

8. Final Inspection — AD 73-04 02 | N/A | N/A | N/A | N/A

To be completed by a different person than the previous steps.
a. Lid assembly for complete welds, and required minimum mesh weld locations.
b. Material lists complete.
c. Overall condition and conformity to drawing(s).

9. Powder Coating — AD 73-04 02 | N/A | N/A | N/A | N/A

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2016-153

Date Opened: 09 NOV 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		**78412-01**	**Lid Assembly**		
Step 1				*Rim Assembly*	304 STAINLESS JC	
	.2		--	3/4" Tube - Long Rim (93.25")	~~4130 Steel~~, ¾" x 0.035 Sqr. Tube	18057
	.2		--	3/4" Tube - Short Rim (22.5")	~~4130 Steel~~, ¾" x 0.035 Sqr. Tube	18057
Step 2				*Weld Rim Assembly*	304 STAINLESS JC.	
	.A/R		--	Welding Rod	~~ER70S-~~2 TIG Rod	17066
Step 3				*Inspection - Rim*	ER308L JC. *None*	
Step 4				*Frame Assembly*	304 STAINLESS JC	
	.4		--	3/4" Tube - Cross Member (21")	~~4130 Steel~~, ¾" x 0.035 Sqr. Tube	18057
Step 5		70405		*Option: Frame Assembly - with walkway*		
	.8		--	1/2" Tube - walkway	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	
Step 6				*Weld Frame Assembly*	304 STAINLESS JC ER 308L JC.	
	.A/R		--	Welding Rod	~~ER70S-2~~ TIG Rod	17066
Step 7				*Inspection - Frame Assembly*	*None*	
Step 8				*Mesh Assembly*	STAINLESS JC.	
	.1		--	Mesh (lid - 92.5" x 22")	3/4-16F Expanded ~~Mild~~ Steel sheet	16009
Step 9				*Weld Mesh*		
	.A/R		--	Welding Rod	~~ER70S-6 MIG Wire~~ ER 308L TIG Rod	17066

Work Order: 2016-153

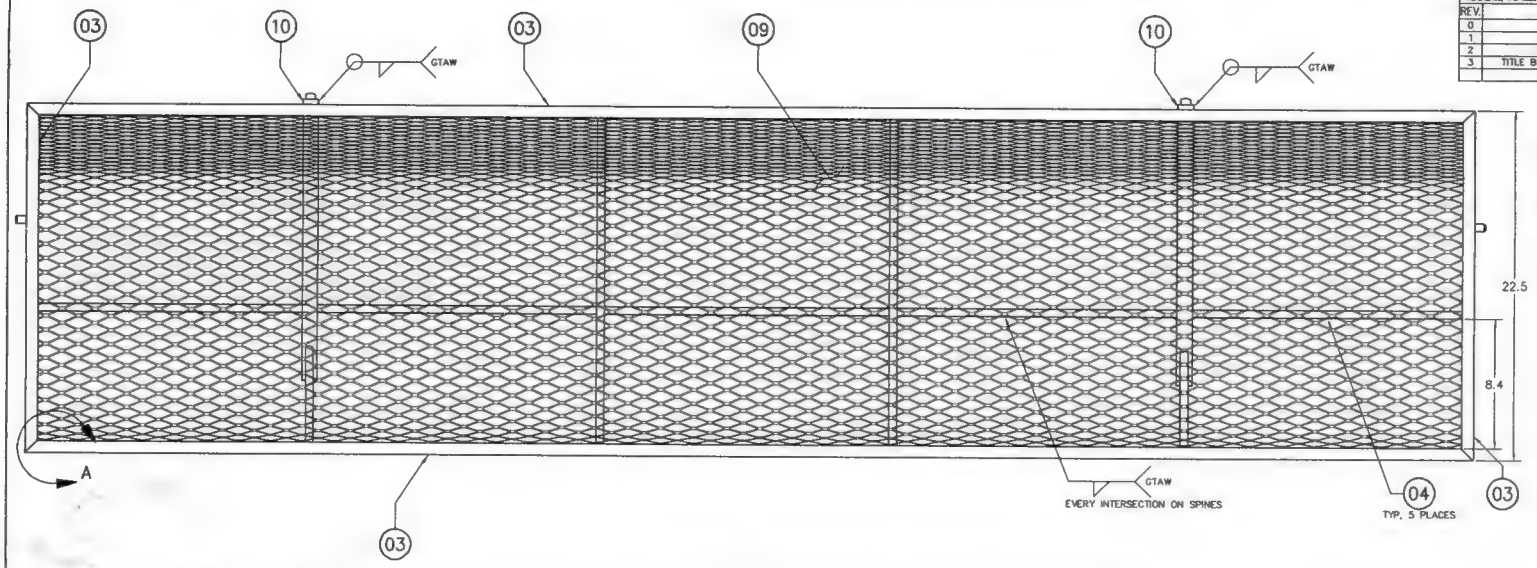
Date Opened: 09 Nov 2016

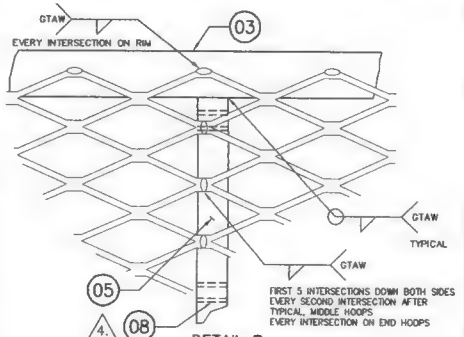
Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				*Weld Lid Components*		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		2017-201
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R		--	Welding Rod	ER308L TIG Rod	17066
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, ½" Dia.	2017-210
	. A/R		--	Welding Rod	ER308L TIG Rod	17066
	. 1		36204-10	Placard Bracket	304 STAINLESS ~~1018 Steel~~, 0.035" Sheet	17050
	. A/R		--	Welding Rod	~~ER70S-~~2 TIG Rod ER308L	17066
Step 11				*Clean Up*		
Step 12				*Inspection - Final Assembly*		
Step 13				Powder Coating		18081

WO#2016-153 S.S.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	25 JAN 08
1	CHANGED ATTACH HOOP FROM 76423-01 TO 76423-07	RR	05 MAR 09
2	CHANGED HANDLE BRACKET, REMOVED ALTERNATE BASKET	BJC	28 JAN 10
3	TITLE BLOCK UPDATED; WELDING ROD UPDATED; REFERENCE DIMS ADDED; SPACER (07) MOVED; CAP (10) ADDED	BJC	11/07/2014

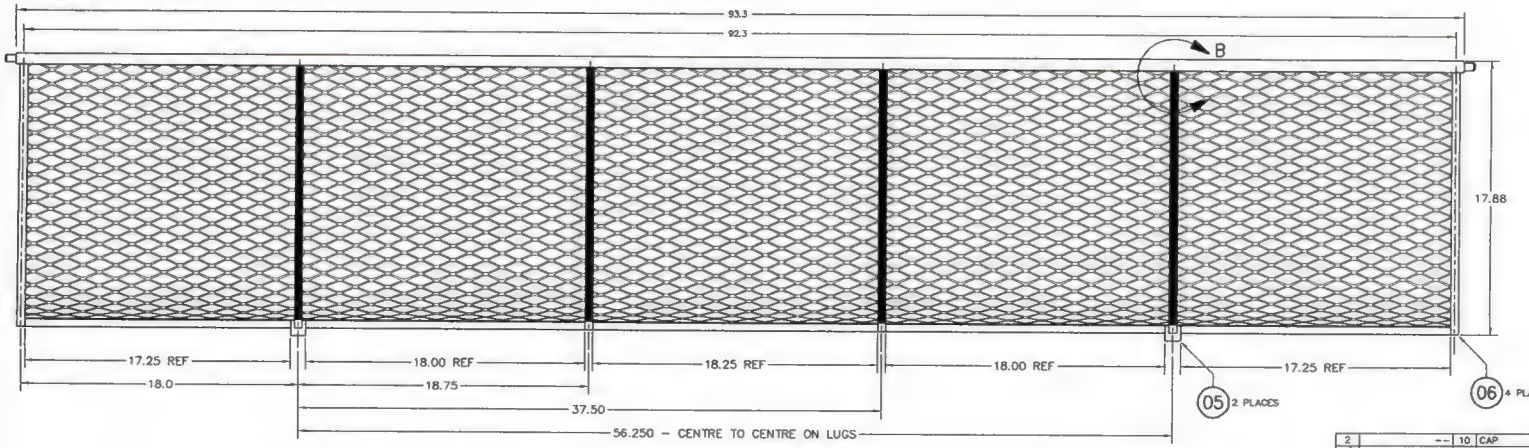


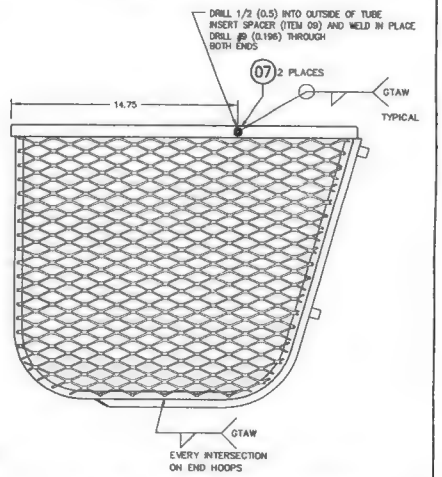


DETAIL B

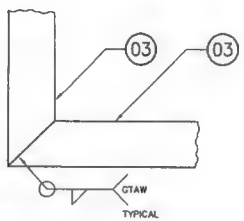
SCALE 1:1

VIEW LOOKING AT INNER SURFACE OF BAKSET





01 BASKET BODY ASSEMBLY



DETAIL A

SCALE 1:1

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL ø30 (0.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
   4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
   STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
4. INSTALL ITEM 8 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 BEFORE WELDING HOOPS TO RIM.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
	78411-01	01	BASKET BODY ASSEMBLY			
		02				
A/R	--	03	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	3/4 X 0.035 SQR TUBE
A/R	--	04	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	1/2 X 0.035 SQR TUBE
4	76421-01	06	HOOP			
2	76423-07	05	ATTACHMENT HOOP			
2	49215-01	07	SPACER			
1	84262-01	08	BASKET HANDLE PROVISIONS ASSEMBLY			
A/R	3/4 - 18F	09	MESH	MILD STEEL	COMMERCIAL	
2	--	10	CAP	MILD STEEL	AISI 1010/1020	0.050 SHEET

APPROVALS		DATE
DRAWN:	R. RATHWELL	25 JAN 08
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

AERO DESIGN LTD.
9685A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.485.2378 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY (LONG)

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78411	3

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket ← * IN S.S.
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2016-153 S.S.

Date Open: Nov 2016

1. Rim Assembly – Basket Body
   a. Cut and fit ¾" x 0.035 material to fit rim jig.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.
   d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
   e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.
   a. Record welding rod PO on attached material list.
   b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube.

3. Inspection
   a. Rim for complete welds

4. Frame assembly – body
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
   b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
   c. Pull required hoops from stock - standard, attachment, handle.
      i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
      ii. Ensure vent hole is located at centre of tube to vent spine tubes.
   d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
      i. Ensure correct order and orientation of hoops. Refer to drawing.
         1. Attachment lugs are on inboard side.
         2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
      ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
      iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
      iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
      v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
   e. Cut ½" x 0.035 material to fit spine jig.
   f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
      i. Refer to applicable drawing for position, not required on some baskets.
   g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
   h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
   i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
    i. Extra large baskets
        1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim
    ii. All other baskets
        1. inboard side of hoops (attachment side) aligns to INSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim, except R44

AD 73-04 05

5. TIG weld frame to rim assembly.
    a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
    b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
    c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
    d. Record welding rod PO on attached material list.

AD 73-04 05

6. Inspection
    a. Frame assembly for complete welds.

dk

7. Mesh assembly.
    a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
    b. Cut mesh to size for body.
    c. Remove surface rust with scotch-brite.
    d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
        i. For extra wide baskets only –
            1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
            2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
            3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
        ii. Using markings on table, align sheet to indicated edge.
        iii. Using markings on table, align 3" tube to required position and clamp tube in place.
        iv. Bend mesh by hand tightly over tube along length of tube.
        v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
        vi. Bend mesh by hand tightly over tube along length of tube.
    e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
    i. General
        1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
        2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
        3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
        4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
    ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
    iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
    iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    v. Clamp mesh to spine in at least 1 place per section.
    vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
    viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
    iv. Cut for front end cutout if required.
i. 90[illegible]1 (P[illegible]1) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/4" down at 60 degrees.
    iv. Fit mesh to front end of basket.

Complete
(initial or SCA #)

8. Weld mesh to frame assembly per drawing. AD 73-04 05
   a. Ensure lug locating jig is in place prior to welding.
   b. General welding requirements for all baskets, MIG welding:
      i. Every intersection at top edges.
      ii. Every intersection at ends.
      iii. First 5 intersections down on hoops, then every second intersection.
      iv. Every intersection along spine.
      v. Extra large baskets – every intersection along corner.
      vi. Every intersection around ends
      vii. Every intersection along struts (if applicable)
   c. Bend and trim cells bent in to fit mesh as required and weld in position.
   d. Grind high spots off body mesh welds on ends before welding end mesh.
   e. *90611 (844) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
   f. Record welding rod PO on attached material list.

9. Weld basket components AD 73-04 05
   a. TIG weld lid prop bushing(s), one or two per drawing.
      i. Record welding rod PO on attached material list.
      ii. Record lip prop bushing WO on attached material list.
   b. TIG weld caps to close top of 1" hoops as applicable.
   c. 94611 (all206L/407 XL ski) only: cut rim over cross tube gap.
      i. Cut inboard rim on aft end. Grind flush with hoops.
      ii. TIG weld caps on open tubes.
      iii. Record cap material PO on attached material list.
   d. 95911 (all 429) only: placard bracket to forward upper corner of basket.
      i. Record welding rod PO on attached material list.
      ii. Record placard bracket WO on attached material list.

10. Clean up
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
    c. Drill through lid prop bushing(s). De-burr hole(s).
    d. Remove surface rust with scotch-brite pad.

11. Final Inspection AD 73-04 02
    To be completed by a different person than the previous steps.
    a. Basket weld assembly for complete welds, and required minimum mesh weld locations.
    b. Fill weld holes – usually on hoops
    c. Overall condition and conformity to drawing(s).
       i. Hoops for height.
       ii. Spine for width and length and alignment.
       iii. Mounting lugs in correct ends.
       iv. Extra strut in hoop if required by drawing.
    d. Material list complete.

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

a. Parts are to be powder coated white in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag basket body assembly and place into stock in preparation for assembly.

AD 73-04 02

Work Order: 2016-153

Date Opened: Nov 2016 S.S.

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		**78411-01**	**Basket Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	15038
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	15038
Step 2				*Weld Rim Assembly* DRM.		
	. A/R		--	Welding Rod	~~ER70S-2 TIG Rod~~ S.S.	14005
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		76421-01	Hoop - standard S.S.	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	11101
	. 2		76423-01	Attachment hoop (aft) S.S.		11101
	. 5		--	1/2" Tube - spine S.S.	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	11101
Step 4.g.		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube S.S.	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	11101
			70406-04	1/2" Tube S.S.	~~4130 Steel~~, ½" x 0.035 Sqr. Tube	11101
Step 5				*Weld Frame Assembly*		
	. A/R		--	Welding Rod	~~ER70S-2 TIG Rod~~ S.S.	14005
Step 6				*Inspection - Frame Assembly*	*None*	
Step 7				*Mesh Assembly*		
	. 1		--	Mesh (Body - 48" x 92.25")	3/4-16F Expanded Mild Steel sheet	16009
	. 2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	16009
Step 8				*Weld Mesh*		
	. A/R		--	Welding Rod	~~ER70S-6 MIG Wire~~ T.I.G. Rod SS.	14005

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S.S.

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 9				*Weld Basket Components*		
Step 9.a.	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	14005
Step 9.b.	. 2		--	Cap	1018 Mild Steel, 0.032" Sheet	3021
	. A/R		--	Welding Rod S.S.	~~ER70S-2~~ TIG Rod	14005
Step 10				*Clean Up*	*None*	
Step 11				*Inspection - Final Assembly*	*None*	
Step 12				Powder Coating		18081